

Work Order ID 133018

Friday, May 22, 2015 11:41:21 AM

133018

Page 1

Item ID: PB67-43001-07

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 5/22/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: mf

Date: 15-5-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-07	D

JUN 15 2015

100 Weld per dwg A/R Aluminum rod Batch: 0.00

100

Large Fab

Large Fab

128316

Memo

0.00

Large Fab

1- Assemble parts on jig DT8813 and weld as per dwg PB67-43001

*** Ensure no burn thru after welding in tube -205 and -197 only where
bushing -265 ***

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Memo

0.00

Quality Control

①

15-0617

DAS
24
9-89

DAS
9
9-89

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

① 15-06-17 DAS 9 9-89

130

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo 111277

0.00

MASK ALL OPENING AND INDICATED AREAS PRIOR TO POWDERCOATING, SEE NOTE 9 SHEET 2-3*

START TIME: 9:10

OVEN TEMPERATURE: 320°

FINISH TIME: 9:40

1 15-6-19 DAS 34 9-89

Work Order ID 133018

Friday, May 22, 2015 11:41:22 AM

133018

Page 3

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N900040100

Setup Start

NS1

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Item Name: Fwd Blade Fold Assembly Weldment

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Required Date: 6/5/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
150	Identify as per dwg & Stock Location: <u>2004</u>	0.00							
150									
Packaging	Memo	0.00							DAS 9 9-89
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

② 15-06-22

② 15-06-22

MLJ JUN 23 2015

MLJ JUN 23 2015

Picklist Print

Friday, May 22, 2015 11:41:21 AM

Page 1

Work Order ID: 133018

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Parent Item: PB67-43001-07

PB67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-25 new issue DD verified by:ec IPP rev B
10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-205W		Manufactured	No				Each	0.0000		1			
PR67-43001-205W									**	111238		UNF 15-6-10	
Outer Tube Weldment													
PB67-43001-197W		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-197W									**	112753		unf-15-6-10	
Outer Tube Weldment													
PB67-43001-203W		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-203W									**	112757		unf 15-6-10	
Square Tube Weldment													
PB67-43001-207W		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-207W									**	99988		unf 15-6-10	
Square Tube Weldment													
PB67-43001-47		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-47									**	133242		unf 15-6-10	
Base Assembly													
PB67-43001-201		Manufactured	No			100	Each	0.0000	1	1			
PR67-43001-201									**	8133240 → 1		JUN 5 1 2015	DAS 24 9-89
Square Tube													
PB67-43001-209		Manufactured	No			100	Each	2.0000	1	1			
PR67-43001-209									**			JUN 5 1 2015	DAS 24 9-89
Square Tube													

Location

Loc Qty

Loc Code

Mezz2

2

112748

2

1

Picklist Print

Friday, May 22, 2015 11:41:21 AM

Page 2

Work Order ID: 133018

133018

Parent Item: PB67-43001-07

PR67-43001-07

Parent Item Name: Fwd Blade Fold Assembly Weldment

Start Date: 5/22/2015

Required Date: 6/5/2015

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-211 Manufactured No

100 Each

0.0000

6 6

PR67-43001-211

Square Tube

PB67-43001-219 Manufactured No

100 Each

3.0000

1 1

PR67-43001-219

Angled Male Eye

**** B133241 → 6**

JUN 5 1 2015

**DAS
24
99-89**

JUN 5 1 2015

**DAS
24
9-89**

Location

Loc Qty

Loc Code

Mezz2

3

110598

3

D3440-7 Manufactured No

100 Each

5.0000

1 1

D3440-7

Detent Clip Base (Supersedes B67-43001-221)

Location

Loc Qty

Loc Code

Mezz2

5

111739

5

D3440-5 Manufactured No

100 Each

5.0000

1 1

D3440-5

Contoured Detent Clip Base (Supersedes B67-43001-217)

MF 15-6-10

Location

Loc Qty

Loc Code

Mezz2

5

111738

5

D3440-15 Manufactured No

100 Each

5.0000

1 1

D3440-15

Contoured Male Eye (Supersedes B67-43001-215)

MF 15-6-10

Location

Loc Qty

Loc Code

Mezz2

5

111737

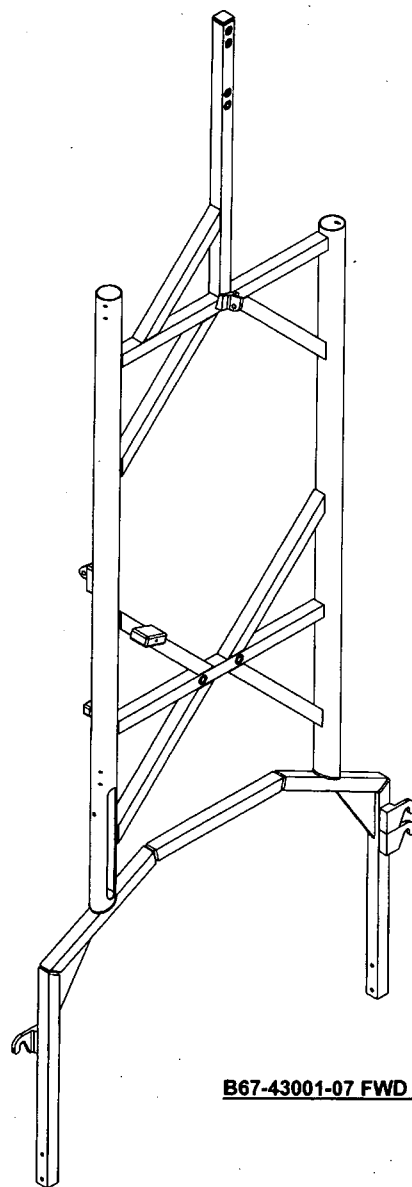
5

MF 15-6-10

Friday, May 22, 2015 11:41:21 AM

Shop Packet Print

Page 2



B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

ITEM	QTY -07	P/N	DESCRIPTION
1	X	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-197W	OUTER TUBE WELDMENT
4	1	B67-43001-201	SQUARE TUBE
5	1	B67-43001-203W	SQUARE TUBE WELDMENT
6	1	B67-43001-205W	OUTER TUBE WELDMENT
12	1	B67-43001-207W	SQUARE TUBE WELDMENT
8	1	B67-43001-209	SQUARE TUBE
9	6	B67-43001-211	SQUARE TUBE
10	1	B67-43001-219	ANGLED MALE EYE
11	1	D3440-5	CONTOURED DETENT CLIP BASE
12	1	D3440-7	DETENT CLIP BASE
13	1	D3440-15	CONTOURED MALE EYE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133018

15-05-27

RELEASED
2014-12-08

D	REVISE BOM AND ANNOTATIONS TO INCLUDE -197W/-203W/-205W & -207W WELDMENTS, DELETE DETAIL C REASON: TO FACILITATE MANUFACTURING	DB	14.07.23
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 5 OF PREMIER AVIATION DRAWING # B67-43001. REASON: SEE PAR #09-011	MB	10.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-07	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	14.07.23	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



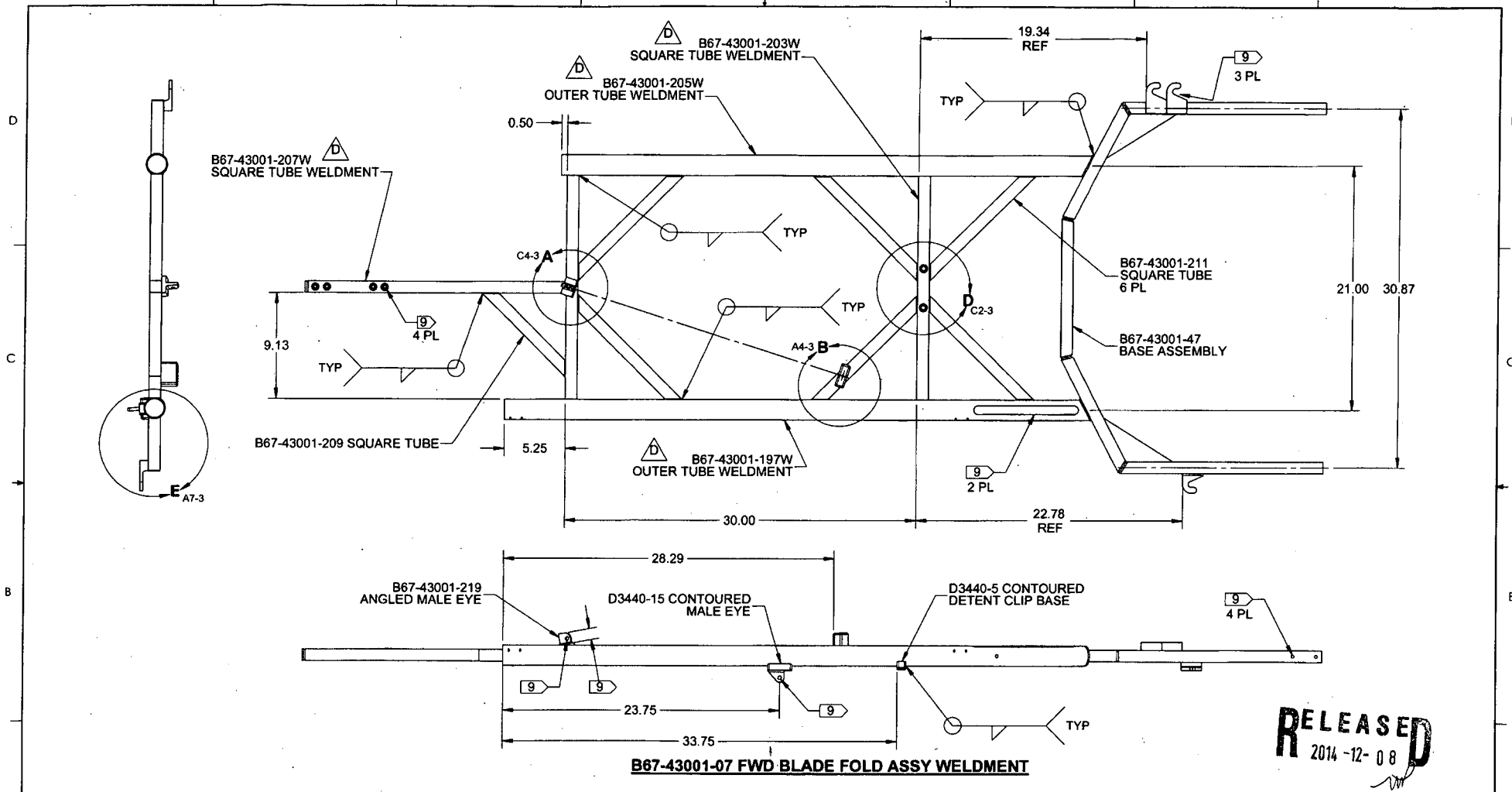
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition			Completed By																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

8 7 6 5 4 3 2 1



B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 10.22 lbs
 - 8) WELDING: PER QSI 004
 - 9) MASKING: ALL OPENINGS AND INDICATED AREAS PRIOR TO POWDER COATING

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-07	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
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2014-12-08

8 7 6 5 4 3 2 1

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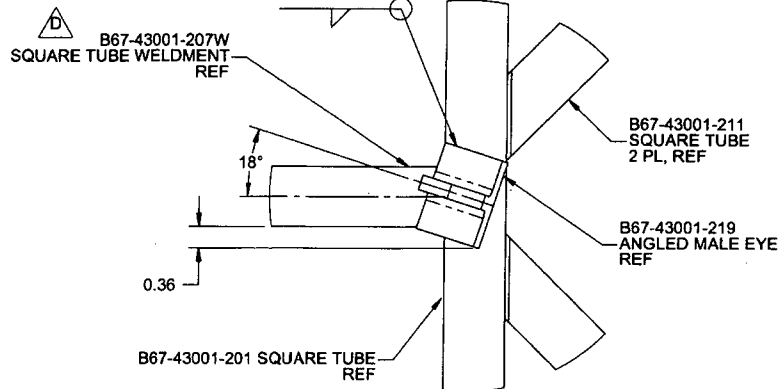


WORK ORDER NON-CONFORMANCE / UPDATE

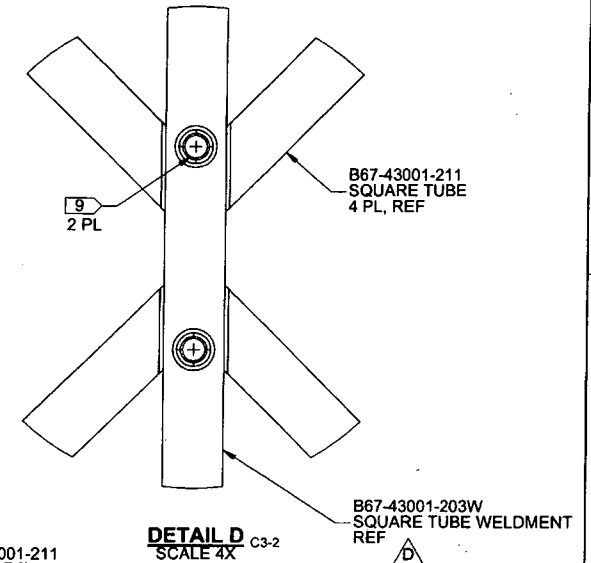
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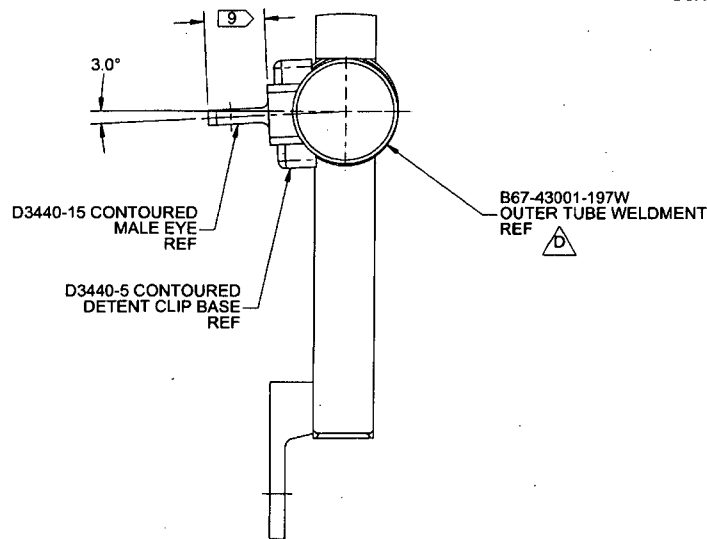
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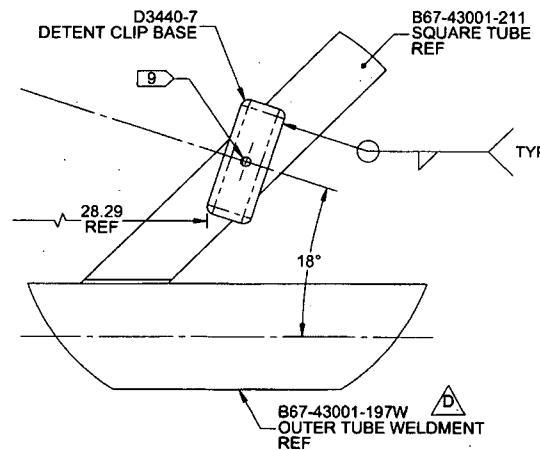
DETAIL A
SCALE 4X C6-2



DETAIL D
SCALE 4X C3-2



DETAIL E
SCALE 4X B8-2



DETAIL B
SCALE 4X C4-2

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2014-12-08

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. D
MFG. APPR.	[Signature]	B67-43001-07	SHEET 3 OF 3
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
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